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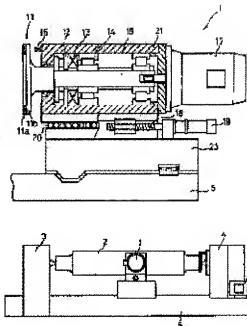
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(54) OFF-LINE ROLL GRINDER

(57)Abstract:

PURPOSE: To grind a hard roll with high efficiency and in a long-time stable manner without causing chattering marks and scratches by using a grinding stone formed of CBN grinding grains or diamond grinding grains.

CONSTITUTION: In a roll grinder which consists of a grinding stone table 1, a tail stock 4 and a spindle base 3, a rotary disk 11b to support the grinding grain portion 11a, formed of CBN grinding grains or diamond grinding grains, of a rotary grinding stone 11 mounted on the grinding stone table 1 is given flexibility as in a flexible cantilever beam to absorb a change in contact line pressure between a roll 2 and the rotary grinding stone 11. The flexibility of the rotary disk 11b is measured and the position of a grinding stone feed motor 19 to the grinding stone table 1 is controlled.



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